

Date: Thursday, 12/20/2007 3:25:13 PM  
 User: Kim Johnston

## Process Sheet

5

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HELI-ACCESS STEP RH (FOLDING)	
Job Number	36498		Part Number	D412630034	
Estimate Number	12568		Drawing Number	IIN D412-630	
P.O. Number	:		Project Number	N/A	
This Issue	12/20/2007	S.O. No. :	Drawing Revision	L	
Prsht Rev.	NC		Material	:	
First Issue	/ /	Type : LARGE FAB ASSY	Due Date	1/31/2008	Qty: 3 Um: Each
Previous Run	35957				
Written By	<i>12/20/07, 12 21</i>				
Checked & Approved By					
Comment	Est. Rev:A	New Issue 06-11-08 JLM			
	est rev B	ecn1019, added D2807-041 EC verified by:DD			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	<i>(S) K5 08-01-22</i>
			<i>In label w/ front of step.</i>
		Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG003	
2.0	D2012107	Clevis	<i>(S) 33585</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch	
		1 D2012-107 Clevis	<i>37101 33585 R</i>
3.0	D2803042	Bracket Assembly	<i>(S) 524617 508 148</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
		1 D2803-042 Bracket Assembly RH	<i>B34017 508 148</i>
4.0	D2804042	Bracket Assembly	<i>(S) 34018 20 11826 (3)</i>
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	
		1 D2804-042 Bracket Assembly RH	<i>34018 20 11826 (3)</i>
			<i>26252 18</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 36498

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2807041 GAS SPRING ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Batch: 35962

*(Signature)*

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	<u>B25923 6P</u>

*(Signature)*

7.0 D3562042 STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

*X*

Pick:

Qty	Part Number	Description	Batch
1	D3562-042	Step Weldment RH	<u>B36409</u>

*(Signature)*

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	<u>B27271 4P</u>

B26770 8P

B28405 3P

*(Signature)*

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	<u>M19633</u>

*(Signature)*

10.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

M100695

*(Signature)* 8/2/20 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: HELI-ACCESS STEP RH (FOLDING)
Job Number: 36498			Part Number: D412630034
Job Number:			
Seq. #: Machine Or Operation:			Description :
Qty	Part Number	Description	Batch
2	AN8C16	Bolt	
11.0	AN310C8	Nut	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Nut Pick: Qty Part Number Description			
2	AN310C8	Nut	M103433
12.0	MS24665302	Cotter Pin	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Cotter Pin Pick: Qty Part Number Description			
2	MS24665-302	Cotter Pin (or AN380C3-4)	M106763
13.0	NAS1515H3	Washer	
Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s) Washer Pick: Qty Part Number Description			
6	NAS1515H3	Washer	M106431
14.0	NAS1515H5L	WASHER	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) WASHER Pick: Qty Part Number Description			
4	NAS1515H5L	Washer	101928
15.0	NAS1515H8	Washer	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Washer Pick: Qty Part Number Description			
4	NAS1515H8	Washer	* 104811 30
			12/21/26 (3)
			M106409X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HELI-ACCESS STEP RH (FOLDING)
Job Number: 36498		Part Number: D412630034
Job Number:		
Seq. #:	Machine Or Operation:	Description :
16.0	MS210433	Nut 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Nut Pick: Qty Part Number Description Batch 4 MS21043-3 Nut <i>M107214</i>		
17.0	MS24693C280	Screw 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Screw Pick: Qty Part Number Description Batch 2 MS24693-C280 Screw (or MS24694-C565) <i>16984 6X / C82/26 (3)</i>		
18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.14  Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: <i>m104929</i>		
COAT exposed HARDWARE WITH LPS PROCYON .  A/R LPS PROCYON BATCH: <i>m17045</i>		<i>MF 08-02-26 (3)</i>
19.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP <i>0802-26 (3)</i>		
20.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
21.0	D28061	Bushing 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing Pick: Packing Kit Qty Part Number Description Batch <i>A</i> Qty Part Number Description Batch <i>B 33590 / C82/01(3)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: HELI-ACCESS STEP RH (FOLDING)
Job Number: 36498			Part Number: D412630034
Job Number:			
Seq. #:	Machine Or Operation:		Description :
22.0	2 D2806-1	Bushing	
	D28063	Bushing	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing Pick: Packing Kit Qty Part Number Description Batch 2 D2806-3 Bushing 36534			
23.0	D28105	Strut	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Strut Pick: Packing Kit Qty Part Number Description Batch 1 D2810-5 Strut 35829			
24.0	D33961	Spacer	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Spacer Pick: Packing Kit Qty Part Number Description Batch 2 D3396-1 Spacer 34025 2P 326771 2P 326654 2P			
25.0	AN4C6A	Bolt	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 1 AN4C6A Bolt M106519			
26.0	AN4C10A	Bolt	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bolt Pick: Packing Kit Qty Part Number Description Batch 1 AN4C10A Bolt M100223 2P M18518 1P			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 36498			Part Number: D412630034
Job Number:			
Seq. #:		Machine Or Operation:	Description :
27.0	AN4C15A	Bolt	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)			
 Bolt			
Pick: Packing Kit			
Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	<u>M103915</u>
28.0	AN44C7A	Eyebolt	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
 Eyebolt			
Pick: Packing Kit			
Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	<u>M104711</u>
29.0	AN5C15A	Bolt	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)			
 Bolt			
Pick: Packing Kit			
Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	<u>M105120</u>
30.0	NAS1515H4	Washer	
			
Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)			
 Washer			
Pick: Packing Kit			
Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	<u>M10471517X M1055164X</u>
31.0	NAS1515H5	Washer	
			
Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)			
 Washer			
Pick: Packing Kit			
Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	<u>M106541</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/02/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 36498		Part Number: D412630034
Job Number:		
Seq. #:	Machine Or Operation:	Description :
32.0	MS210434	Nut
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s) Nut Pick: Packing Kit Qty Part Number Description Batch 4 MS21043-4 Nut M107101		
33.0	MS210435	Nut
Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s) Nut Pick: Packing Kit Qty Part Number Description Batch 3 MS21043-5 Nut M107191		CSP/27(B)
34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
		08-02-27 (3)
Comment: INSPECT 100% KITS FOR COMPLETENESS		is separated.
35.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-034 Location: A PPP Rev: A		8b127 SD (3x) B
36.0	QC21	FINAL INSPECTION/W/O RELEASE
		(3)
Comment: FINAL INSPECTION/W/O RELEASE		D080217
Job Completion		2008/2/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

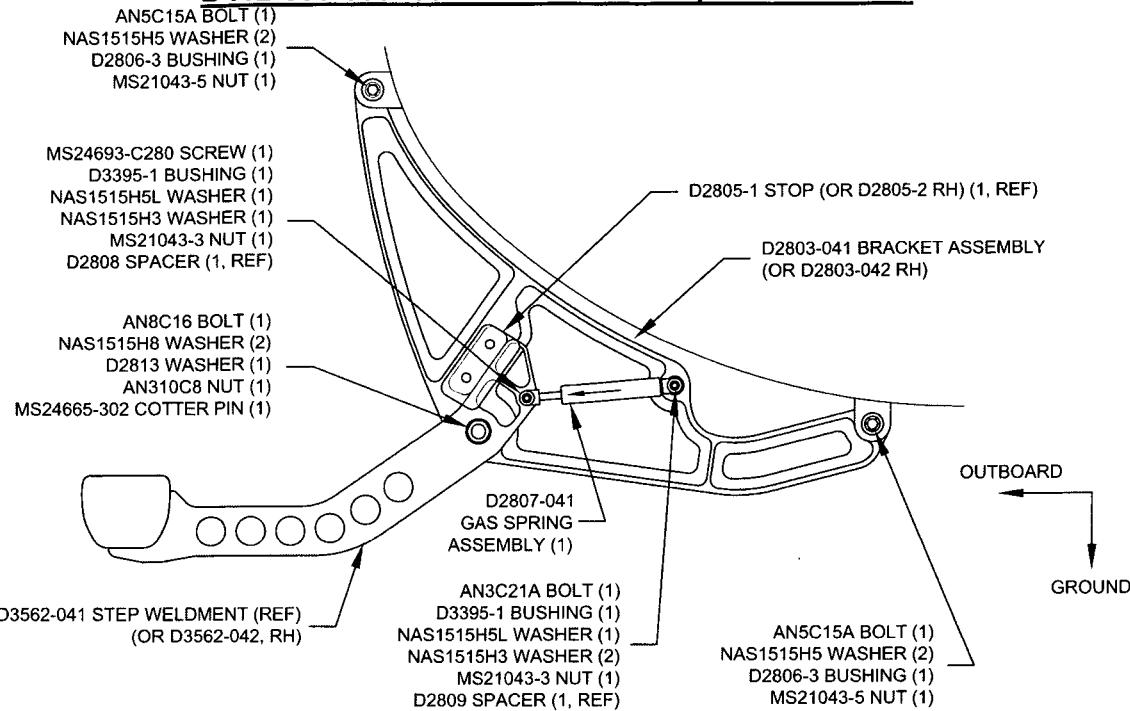
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

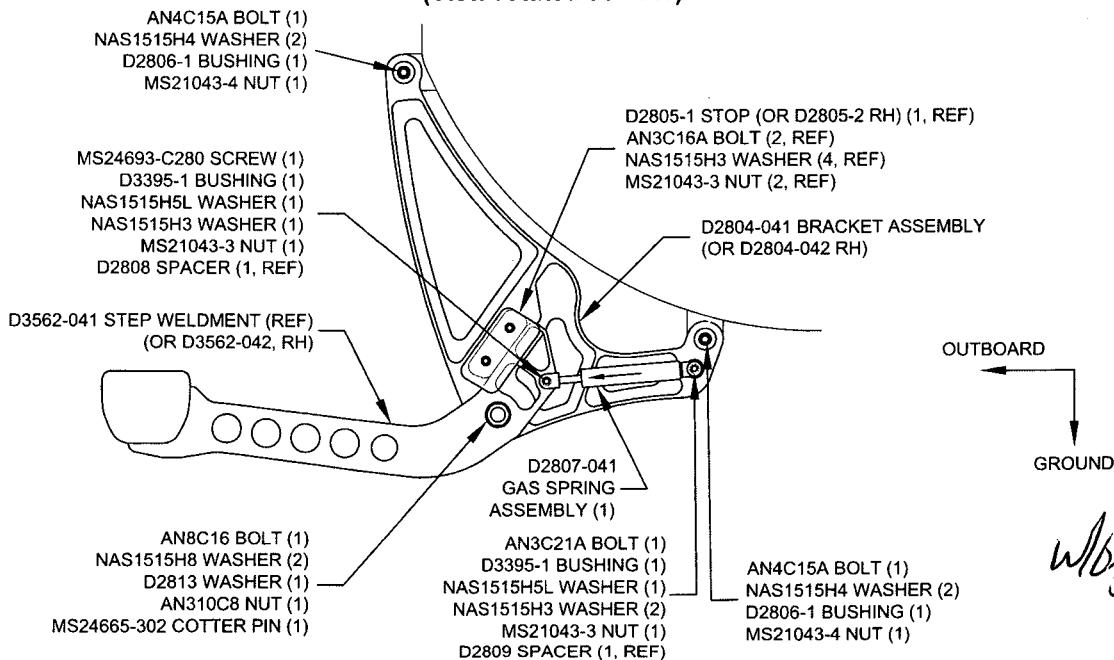
NOTE: Date & initial all entries

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
			1	D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. *36498*

D412-630-033/-034 Heli-Access-Step™ Installation

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation  
(View rotated 90° CW)**

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Revision: L  
Date: 07.09.30